



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-541
Job Sheet 195723



Part No: D206-642-541

Job Qty: 1 pcs

Part Name: Repl.Skid.,High Gear,Std Wearplates Fits LH/RH, DART Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV G IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC IPP Rev:F 08-06-02 add comment DD verified by:EC IPP Rev:G 08-10-09 revise details DD verified by:EC IPP REV:H 13.09.05 CHG004/ ECN13-634 DD VERF.JLM IPP REV:I 14.04.28 AS PER ECN14-520 DD VERF.JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/5/19		0.00	2.17	Skidtubes - 1		GO
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
114	QC 5	1 pcs	7/5/19		0.00	0.00	QC 5 - 10		JUN 13 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
116	QC 10	1 pcs	7/5/19		0.00	0.00	QC 5 - 68		JUN 13 2019
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 10 - 10		JUN 13 2019
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		

Plex 5/30/19 9:13 AM Dart.Guerin.Kimberley



Container No: S187861



Part: D206-642-541

Job No: 195723

Serial No/Batch: S187861

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17 TO STC SH98-

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

120 Handfinish - 1-1 Chemical- B4B	1 pcs	7/5/19	0.00 0.68	QC 10 - 50					
				QC 10 - 58					
				QC 10 - 9					
				Handfinish - 1 - 1 - B4B					
				Handfinish - 1 - 2 - B4B					
				Handfinish - 1 - 3 - B4B	JUN 19 2019				
				Handfinish - 1 - 4 - B4B					
				Handfinish - 1 - 5 - B4B					
				Handfinish - 1 - 6 - B4B					
				Handfinish - 1 - 7 - B4B					
				Handfinish - 1 - 8 - B4B					
				Handfinish - 1 - 9 - B4B					
				Handfinish - 1 - 10 - B4B					
				Handfinish - 1 - 11 - B4B					
				Handfinish - 1 - 12 - B4B					
				Handfinish - 1 - 13 - B4B					
				Handfinish - 1 - 14 - B4B					
				Handfinish - 1 - 15 - B4B					
				Handfinish - 1 - 16 - B4B					
				Handfinish - 1 - 17 - B4B					
				Handfinish - 1 - 18 - B4B					
				Handfinish - 1 - 19 - B4B					
				Handfinish - 1 - 20 - B4B					
				Handfinish - 1 - 21 - B4B					
				Handfinish - 1 - 22 - B4B					
130 QC 7	1 pcs	7/5/19	0.00 0.00	QC 7 - 10					
				QC 7 - 13					
				QC 7 - 14					
				QC 7 - 15					
				QC 7 - 17					
				QC 7 - 18					
				QC 7 - 19					
				QC 7 - 2					
				QC 7 - 28					
				QC 7 - 3					
				QC 7 - 30					
				QC 7 - 34					
				QC 7 - 36					
				QC 7 - 37					
				QC 7 - 41					
				QC 7 - 47					
				QC 7 - 48					
				QC 7 - 51					
				QC 7 - 58					
				QC 7 - 59					
				QC 7 - 60	M/G				
				QC 7 - 9					
				QC 7 - 68					
								Plex 5/30/19 9:13 AM Dart.Guerin.Kimberley	

150 Skidtubes - 2 - B4B	1 pcs	7/5/19	0.00 2.08	QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				Skidtubes - 1 - B4B	DD
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
160 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
170 Skidtubes - 3 - B4B	1 pcs	7/5/19	0.00 2.17	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	BE
				Skidtubes - 4 - B4B	TF
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
180 QC 5	1 pcs	7/5/19	0.00 0.00	Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
190 Skidtubes - 4 - B4B	1 pcs	7/5/19	0.00 2.75	Skidtubes - 1 - B4B	DD
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	

200 QC 5	1 pcs	7/5/19	0.00 0.00	Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	JUL 24 2019 DAS 68 9-89
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
QC 5 - 40					
210 QC 10	1 pcs	7/5/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	JUL 24 2019 DAS 50 9-89
				QC 10 - 58	
QC 10 - 9					
220 Handfinish - 2-1 Pressure- B4B	1 pcs	7/5/19	0.00 0.45	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	SA JUL 25 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
230 Spray Paint - 2 - B4B	1 pcs	7/5/19	0.00 0.40	Spray Paint - 1 - B4B	AD 19-7-28
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
240 QC 14	1 pcs	7/5/19	0.00 0.00	QC 14 - 15	JUL 19-8-21
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
244 Handfinish - 3-1- WingWalk- B4B	1 pcs	7/5/19	0.00 0.50	Handfinish - 3 - 1 - B4B	JUL 19-8-21
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
246 QC 3	1 pcs	7/5/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
QC 3 - 3					
				Plex 5/30/19 9:13 AM Dart.Guerin.Kimberley	

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					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	BF819-08-21
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
250 Handfinish - 4-1-Assembly-B4B	1 pcs	7/5/19	0.00 0.45		Handfinish - 4 - 1 - B4B	HL 14-8-21
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
260 QC 5	1 pcs	7/5/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
270 Handfinish - 4-2-Assembly-B4B	1 pcs	7/5/19	0.00 0.68		Handfinish - 4 - 1 - B4B	HL 14-8-21
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 -	

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				B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
280 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
290 Packaging 3-1 - Stock - B4B	1 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

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AUG 26 2019
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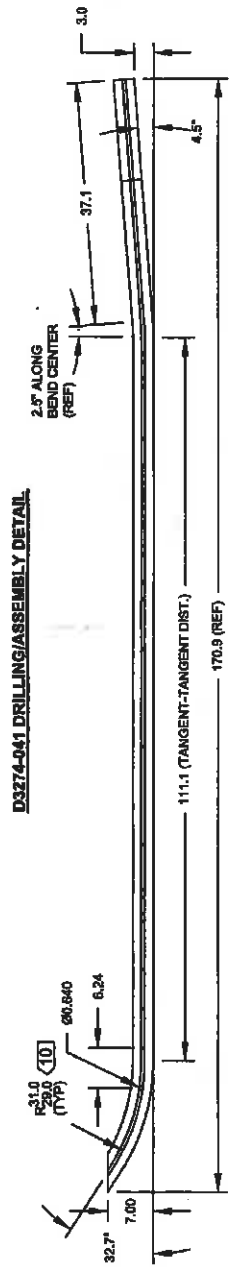
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
295 DC - 1 - B4B	1	7/5/19	0.00 0.00	DC - 1 - B4B	AUG 27 2019
	pcs			DC - 2 - B4B	
300 QC 21 - FG	1	7/5/19	0.00 0.00	QC 21 - FG - 21	AUG 27 2019
	pcs			QC 21 - FG - 70	
				QC 21 - FG - 53	PZ Fb Doc K

Part Op 110 - (Skidtubes) ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- remove fwd indexing ridge as per
Descriptions: dwg D3274. Prepare for welding 2- weld fwd cap as per dwg D3274 and QSI004 AR Aluminum Rod
Batch: 3- grind fwd cap weld on top surface only 4- Cut AFT end of tube at 170.9" as per dwg D3274
and deburr end. 5-Drill Aft cap pilot hole using DT8025 6 -Cleco DT8025 in position and install pilot hole drill Jig
DT8742A,B,C,D and DT8742. Drill 3/16" pilot holes as per Dwg D3274 7 -Remove inner indexing ridge on aft end of
skidtube as per Dwg D3274 scribe batch # 8 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.
114 - (QC5- Inspect part completeness to step on W/O)
116 - (QC10- Inspect visual per QSI004- ground welds)
120 - (Chemical Conversion Coat per QSI005 4.1)
130 - (QC7-Inspect Chemical Conversion Coat)
150 - (Skidtubes) 1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274 2-Deburr crossbolt spacer holes
as per Dwg D3274 and blow out chips from inside the tube 3-Bond web in place as per Dwg D3274 & QSI 015. (Adhere
for 12 hours)
160 - (QC5- Inspect part completeness to step on W/O)
170 - (Skidtubes) 1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt
spacer holes to maintain web position. 2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES
TO .297" . Deburr 3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR
INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF
TUBES 4- Countersink crossbolt spacer holes as per Dwg D3274 5- prepare for welding
180 - (QC5- Inspect part completeness to step on W/O)
190 - (Skidtubes) 1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back
drill each hole before welding the other side. Use aluminum rod 3-Grind cross bolt welds flush as per Dwg D3274.
****INSPECT FOR PIN HOLES IN WELD**** 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.
200 - (QC5- Inspect part completeness to step on W/O)
210 - (QC10- Inspect visual per QSI004- ground welds)
220 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do
not acid etch
230 - (Spray Paint / NDT Room) Make sure Nut Plate Thread is protected using paint screw,. 1- PRIME AS PER DWG
AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5189559 2- PAINT WHITE AS PER DWG AND
QSI 005 4.2 PAINT BATCH: 5192331
240 - (QC14- Inspect Spray Paint)
244 - (Wing Walk as per dwg QSI005 4.4 Batch)
246 - (QC3- Inspect Part Finish)
250 - (Assemble as per dwg) 1-Install Nut Plate as per Dwg D3274. Apply LPS-PROCYON to Nut Plate and rivets.
260 - (QC5- Inspect part completeness to step on W/O) Inspect Nut Plate & Inserts
270 - (Assemble as per dwg) 1-Install wearpads as per Dwg D3274. 2-Install ring as per Dwg D3274 3-Inspect for foreign
objects as per QSI 024 4-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.
280 - (QC5- Inspect part completeness to step on W/O)
290 - (Identify as per dwg & Stock Location:) Location : FG073
295 - (Document Control) Photocopy bluefile & type labels per PPP D206-642- 541 CHG005
300 - (QC21- Final Inspection - Work Order Release) 4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 using
DT10280 and deburr.

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D3274-041BENT	Skidtube Assembly 206	1 pcs (1 ea)	110-Skidtubes - 1	5109144
D3285-1	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5145073
D3282-041	Float Web (206L/407)	1 pcs (1 ea)	150-Skidtubes - 2 - B4B	5191355
D2649	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5136881
D3275-1	Cross Bolt Spacer	12 pcs (12 ea)	190-Skidtubes - 4 - B4B	5148269
ALS4-1032-130	Rivnut	78 Ea (78 ea)	250-Handfinish - 4-1-Assembly-B4B	5057257
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	5099573
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	250-Handfinish - 4-1-Assembly-B4B	F119013
D3415-041	Nut Plate	1 pcs (1 ea)	250-Handfinish - 4-1-Assembly-B4B	F147131
AN3C4A	Bolt	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5192131
AN4C5A	Bolt	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5057496
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5160607
D3413-1	O-Ring	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	X 502076
D3537-1	Wearpad	9 pcs (9 ea)	270-Handfinish - 4-2-Assembly-B4B	5204500
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5195631
D3672-1	Washer, Phenolic	2 pcs (2 ea)	270-Handfinish - 4-2-Assembly-B4B	F164000
D4956-15	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5200824
D4956-23	Wearplate Center Fwd	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201848
D4956-35	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201108
D4956-39	Wearplate Center Aft	1 pcs (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5201005
NAS1149C0332R	Washer	80 Ea (80 ea)	270-Handfinish - 4-2-Assembly-B4B	5193136
NAS1149C0463R	Washer	1 Ea (1 ea)	270-Handfinish - 4-2-Assembly-B4B	5104377

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D3274-041BENT	1	5	0
	D3285-1	1	15	0
	D3282-041	1	1	0
150-Skidtubes - 2 - B4B	D2649	12	70	0
	D3275-1	12	104	0
190-Skidtubes - 4 - B4B	ALS4-1032-130	78	7,594	0
	CCR264SS3-3	2	159	0
	CR3212-4-03	2	84	0
	D3415-041	1	9	0
	AN3C4A	80	1,176	0
250-Handfinish - 4-1-Assembly-B4B	AN4C5A	1	55	0
	D2646	1	33	0
	D3413-1	1	17	0
	D3537-1	9	68	0
	D3537-3	1	18	0
	D3672-1	2	1,729	0
	D4956-15	1	4	0
	D4956-23	1	10	0
	D4956-35	1	8	0
	D4956-39	1	1	0
	NAS1149C0332R	80	3,404	0
	NAS1149C0463R	1	288	0
270-Handfinish - 4-2-Assembly-B4B				

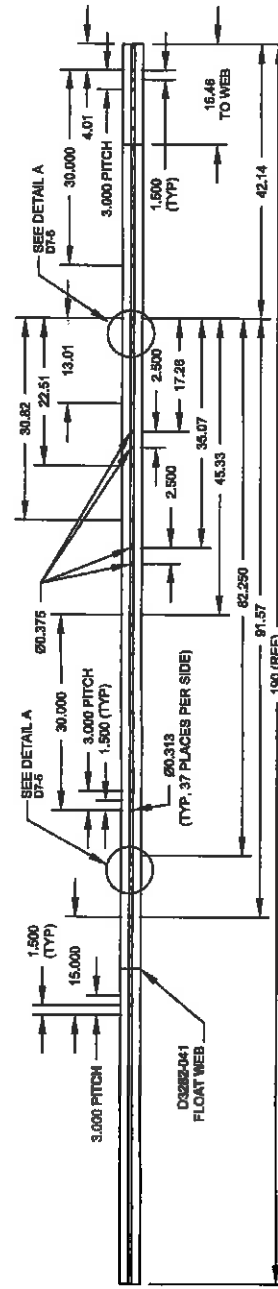
Part Specifications				
Specifications could not be found.				



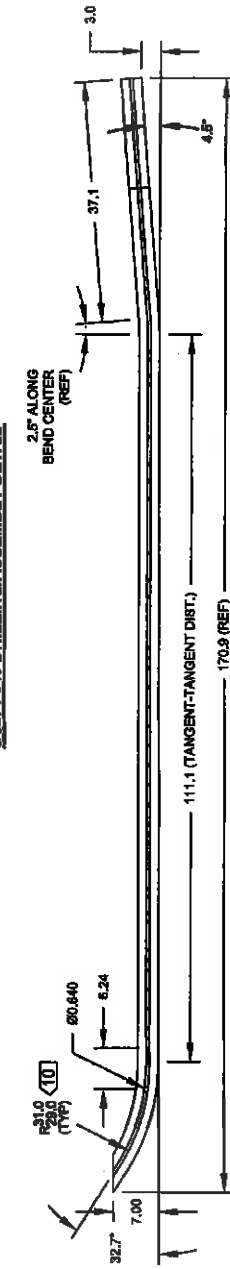
D3274-041 BEND/DRILLING DETAIL



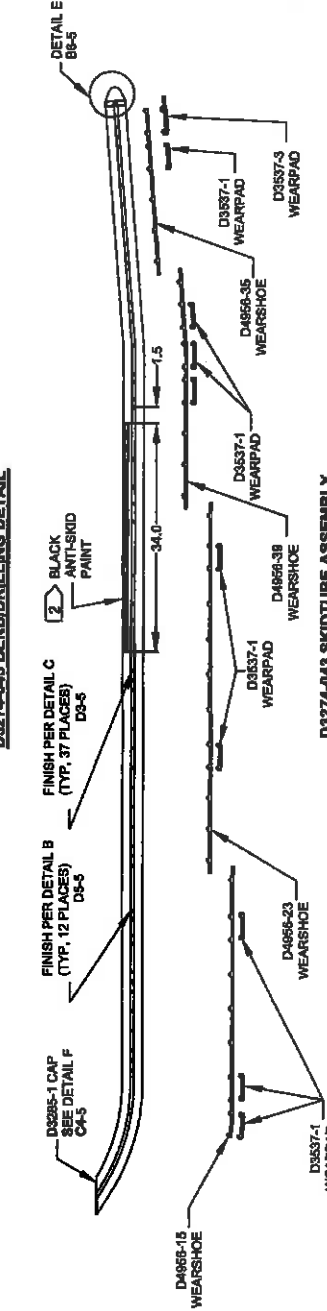
RELEASED
2016-07-26



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY (SEE DETAIL D FOR WEARSHOE INSTALLATION)

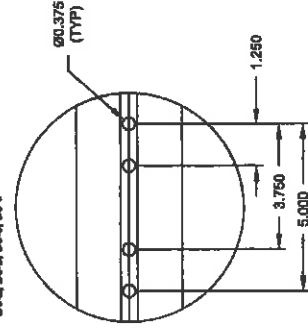
DESIGN	CP	DART AEROSPACE USA, INC
DRAWN	RF	EUGENE, OR
CHECKED	AK	DRAWING NO. D3274
MFG. APPR.	JLM	REV. G SHEET 3 OF 6
APPROVED	DS	TITLE SKIDTUBE ASSEMBLY
DATE	16.04.25	SCALE NTS

RELEASED
2016-07-26



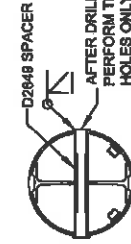
RELEASED
2016-07-26

DETAIL A: DRILL DETAIL
D342, D343, D344, D345



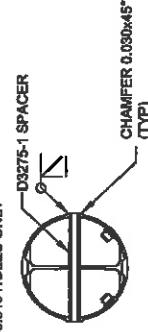
DETAIL B
B342, B343

FOR Ø0.375 HOLES ONLY

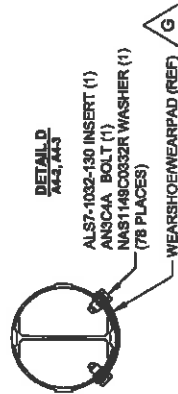


DETAIL C
C342, C343

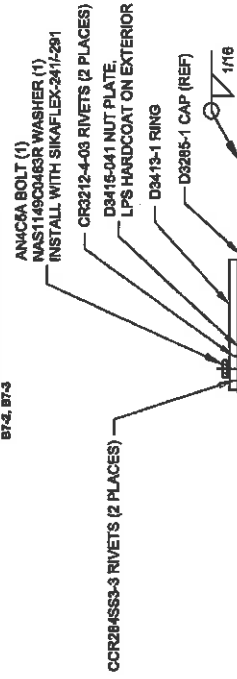
FOR Ø0.313 HOLES ONLY



DETAIL D
D442, D443



DETAIL F: END FINISHING DETAIL
F342, F343



DETAIL E
E342, E343



DETAIL F NOTES
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART Q31 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

Ø0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D3285-1 CAP (REF)

REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

ORIENTATION
OF D3415-041

CCR284SS3-3 RIVETS (2 PLACES)
D3415-041 NUT PLATE
LPS HARDCOAT ON EXTERIOR
D3413-1 RING
D3285-1 CAP (REF)

DETAIL G
G342, G343

FOR Ø0.313 HOLES ONLY

DETAIL H
H342, H343

FOR Ø0.313 HOLES ONLY

DETAIL I
I342, I343

FOR Ø0.313 HOLES ONLY

DETAIL J
J342, J343

FOR Ø0.313 HOLES ONLY

DETAIL K
K342, K343

FOR Ø0.313 HOLES ONLY

DETAIL L
L342, L343

FOR Ø0.313 HOLES ONLY

DETAIL M
M342, M343

FOR Ø0.313 HOLES ONLY

DETAIL N
N342, N343

FOR Ø0.313 HOLES ONLY

DETAIL O
O342, O343

FOR Ø0.313 HOLES ONLY

DETAIL P
P342, P343

FOR Ø0.313 HOLES ONLY

DETAIL Q
Q342, Q343

FOR Ø0.313 HOLES ONLY

DETAIL R
R342, R343

FOR Ø0.313 HOLES ONLY

DETAIL S
S342, S343

FOR Ø0.313 HOLES ONLY

DETAIL T
T342, T343

FOR Ø0.313 HOLES ONLY

DETAIL U
U342, U343

FOR Ø0.313 HOLES ONLY

DETAIL V
V342, V343

FOR Ø0.313 HOLES ONLY

DETAIL W
W342, W343

FOR Ø0.313 HOLES ONLY

DETAIL X
X342, X343

FOR Ø0.313 HOLES ONLY

DETAIL Y
Y342, Y343

FOR Ø0.313 HOLES ONLY

DETAIL Z
Z342, Z343

FOR Ø0.313 HOLES ONLY

DETAIL AA
AA342, AA343

FOR Ø0.313 HOLES ONLY

DETAIL AB
AB342, AB343

FOR Ø0.313 HOLES ONLY

DETAIL AC
AC342, AC343

FOR Ø0.313 HOLES ONLY

DETAIL AD
AD342, AD343

FOR Ø0.313 HOLES ONLY

DETAIL AE
AE342, AE343

FOR Ø0.313 HOLES ONLY

DETAIL AF
AF342, AF343

FOR Ø0.313 HOLES ONLY

DETAIL AG
AG342, AG343

FOR Ø0.313 HOLES ONLY

DETAIL AH
AH342, AH343

FOR Ø0.313 HOLES ONLY

DETAIL AI
AI342, AI343

FOR Ø0.313 HOLES ONLY

DETAIL AJ
AJ342, AJ343

FOR Ø0.313 HOLES ONLY

DETAIL AK
AK342, AK343

FOR Ø0.313 HOLES ONLY

DETAIL AL
AL342, AL343

FOR Ø0.313 HOLES ONLY

DETAIL AM
AM342, AM343

FOR Ø0.313 HOLES ONLY

DETAIL AN
AN342, AN343

FOR Ø0.313 HOLES ONLY

DETAIL AO
AO342, AO343

FOR Ø0.313 HOLES ONLY

DETAIL AP
AP342, AP343

FOR Ø0.313 HOLES ONLY

DETAIL AQ
AQ342, AQ343

FOR Ø0.313 HOLES ONLY

DETAIL AR
AR342, AR343

FOR Ø0.313 HOLES ONLY

DETAIL AS
AS342, AS343

FOR Ø0.313 HOLES ONLY

DETAIL AT
AT342, AT343

FOR Ø0.313 HOLES ONLY

DETAIL AU
AU342, AU343

FOR Ø0.313 HOLES ONLY

DETAIL AV
AV342, AV343

FOR Ø0.313 HOLES ONLY

DETAIL AW
AW342, AW343

FOR Ø0.313 HOLES ONLY

DETAIL AX
AX342, AX343

FOR Ø0.313 HOLES ONLY

DETAIL AY
AY342, AY343

FOR Ø0.313 HOLES ONLY

DETAIL AZ
AZ342, AZ343

FOR Ø0.313 HOLES ONLY

DETAIL BA
BA342, BA343

FOR Ø0.313 HOLES ONLY

DETAIL BB
BB342, BB343

FOR Ø0.313 HOLES ONLY

DETAIL BC
BC342, BC343

FOR Ø0.313 HOLES ONLY

DETAIL BD
BD342, BD343

FOR Ø0.313 HOLES ONLY

DETAIL BE
BE342, BE343

FOR Ø0.313 HOLES ONLY

DETAIL BF
BF342, BF343

FOR Ø0.313 HOLES ONLY

DETAIL BG
BG342, BG343

FOR Ø0.313 HOLES ONLY

DETAIL BH
BH342, BH343

FOR Ø0.313 HOLES ONLY

DETAIL BI
BI342, BI343

FOR Ø0.313 HOLES ONLY

DETAIL BJ
BJ342, BJ343

FOR Ø0.313 HOLES ONLY

DETAIL BK
BK342, BK343

FOR Ø0.313 HOLES ONLY

DETAIL BL
BL342, BL343

FOR Ø0.313 HOLES ONLY

DETAIL BM
BM342, BM343

FOR Ø0.313 HOLES ONLY

DETAIL BN
BN342, BN343

FOR Ø0.313 HOLES ONLY

DETAIL BO
BO342, BO343

FOR Ø0.313 HOLES ONLY

DETAIL BP
BP342, BP343

FOR Ø0.313 HOLES ONLY

DETAIL BQ
BQ342, BQ343

FOR Ø0.313 HOLES ONLY

DETAIL BR
BR342, BR343

FOR Ø0.313 HOLES ONLY

DETAIL BS
BS342, BS343

FOR Ø0.313 HOLES ONLY

DETAIL BT
BT342, BT343

FOR Ø0.313 HOLES ONLY

DETAIL BU
BU342, BU343

FOR Ø0.313 HOLES ONLY

DETAIL BV
BV342, BV343

FOR Ø0.313 HOLES ONLY

DETAIL BW
BW342, BW343

FOR Ø0.313 HOLES ONLY

DETAIL BX
BX342, BX343

FOR Ø0.313 HOLES ONLY

DETAIL BY
BY342, BY343

FOR Ø0.313 HOLES ONLY

DETAIL BZ
BZ342, BZ343

FOR Ø0.313 HOLES ONLY

DETAIL CA
CA342, CA343

FOR Ø0.313 HOLES ONLY

DETAIL CB
CB342, CB343

FOR Ø0.313 HOLES ONLY

DETAIL CC
CC342, CC343

FOR Ø0.313 HOLES ONLY

DETAIL CD
CD342, CD343

FOR Ø0.313 HOLES ONLY

DETAIL CE
CE342, CE343

FOR Ø0.313 HOLES ONLY

DETAIL CF
CF342, CF343

FOR Ø0.313 HOLES ONLY

DETAIL CG
CG342, CG343

FOR Ø0.313 HOLES ONLY

DETAIL CH
CH342, CH343

FOR Ø0.313 HOLES ONLY

DETAIL CI
CI342, CI343

FOR Ø0.313 HOLES ONLY

DETAIL CJ
CJ342, CJ343

FOR Ø0.313 HOLES ONLY

DETAIL CK
CK342, CK343

FOR Ø0.313 HOLES ONLY

DETAIL CL
CL342, CL343

FOR Ø0.313 HOLES ONLY

DETAIL CM
CM342, CM343

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DETAIL CN
CN342, CN343

FOR Ø0.313 HOLES ONLY

DETAIL CO
CO342, CO343

FOR Ø0.313 HOLES ONLY

DETAIL CP
CP342, CP343

FOR Ø0.313 HOLES ONLY

DETAIL CQ
CQ342, CQ343

FOR Ø0.313 HOLES ONLY

DETAIL CR
CR342, CR343

FOR Ø0.313 HOLES ONLY

DETAIL CS
CS342, CS343

FOR Ø0.313 HOLES ONLY

DETAIL CT
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FOR Ø0.313 HOLES ONLY

DETAIL CU
CU342, CU343

FOR Ø0.313 HOLES ONLY

DETAIL CV
CV342, CV343

FOR Ø0.313 HOLES ONLY

DETAIL CW
CW342, CW343

FOR Ø0.313 HOLES ONLY

DETAIL CX
CX342, CX343

FOR Ø0.313 HOLES ONLY

DETAIL CY
CY342, CY343

FOR Ø0.313 HOLES ONLY

DETAIL CZ
CZ342, CZ343

FOR Ø0.313 HOLES ONLY

DETAIL DA
DA342, DA343

FOR Ø0.313 HOLES ONLY

DETAIL DB
DB342, DB343

FOR Ø0.313 HOLES ONLY

DETAIL DC
DC342, DC343

FOR Ø0.313 HOLES ONLY

DETAIL DD
DD342, DD343

FOR Ø0.313 HOLES ONLY

DETAIL DE
DE342, DE343

FOR Ø0.313 HOLES ONLY

DETAIL DF
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FOR Ø0.313 HOLES ONLY

DETAIL DG
DG342, DG343

FOR Ø0.313 HOLES ONLY

DETAIL DH
DH342, DH343

FOR Ø0.313 HOLES ONLY

DETAIL DI
DI342, DI343

FOR Ø0.313 HOLES ONLY

DETAIL DJ
DJ342, DJ343

FOR Ø0.313 HOLES ONLY

DETAIL DK
DK342, DK343

FOR Ø0.313 HOLES ONLY

DETAIL DL
DL342, DL343

FOR Ø0.313 HOLES ONLY

DETAIL DM
DM342, DM343

FOR Ø0.313 HOLES ONLY

DETAIL DN
DN342, DN343

FOR Ø0.313 HOLES ONLY

DETAIL DO
DO342, DO343

FOR Ø0.313 HOLES ONLY

DETAIL DP
DP342, DP343

FOR Ø0.313 HOLES ONLY

DETAIL DQ
DQ342, DQ343

FOR Ø0.313 HOLES ONLY

DETAIL DR
DR342, DR343

FOR Ø0.313 HOLES ONLY

DETAIL DS
DS342, DS343

FOR Ø0.313 HOLES ONLY

DETAIL DT
DT342, DT343

FOR Ø0.313 HOLES ONLY

DETAIL DU
DU342, DU343

FOR Ø0.313 HOLES ONLY

DETAIL DV
DV342, DV343

FOR Ø0.313 HOLES ONLY

DETAIL DW
DW342, DW343

FOR Ø0.313 HOLES ONLY

DETAIL DX
DX342, DX343

FOR Ø0.313 HOLES ONLY

DETAIL DY
DY342, DY343

FOR Ø0.313 HOLES ONLY

DETAIL DZ
DZ342, DZ343

FOR Ø0.313 HOLES ONLY

DETAIL EA
EA342, EA343

FOR Ø0.313 HOLES ONLY

DETAIL EB
EB342, EB343

FOR Ø0.313 HOLES ONLY

DETAIL EC
EC342, EC343

FOR Ø0.313 HOLES ONLY

DETAIL ED
ED342, ED343

FOR Ø0.313 HOLES ONLY

DETAIL EE
EE342, EE343

FOR Ø0.313 HOLES ONLY

DETAIL EF
EF342, EF343

FOR Ø0.313 HOLES ONLY

DETAIL EG
EG342, EG343

FOR Ø0.313 HOLES ONLY

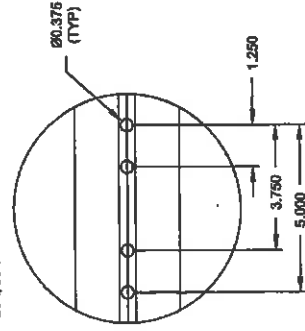
DETAIL EH
EH342, EH343

FOR Ø0.313 HOLES ONLY

DETAIL EI
EI342, EI343

FOR Ø0.313 HOLES ONLY

DETAIL G: DRILL DETAIL
D4, D3.4



DETAIL H
B4-4

FOR Ø0.375 HOLES ONLY

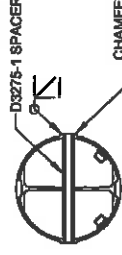


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:

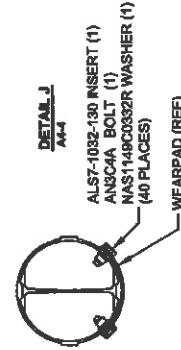
1. CHAMFER HOLE 0.030x45°
2. INSERT D2849 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL I
B4-4

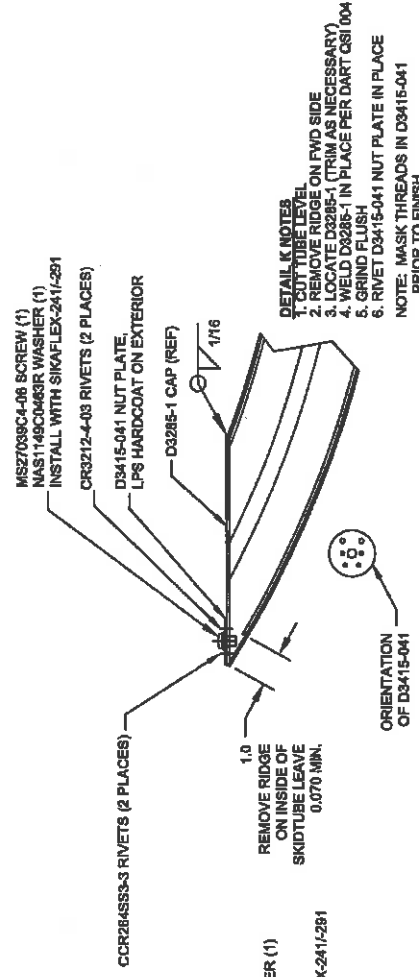
FOR Ø0.313 HOLES ONLY



DETAIL J
A4-4

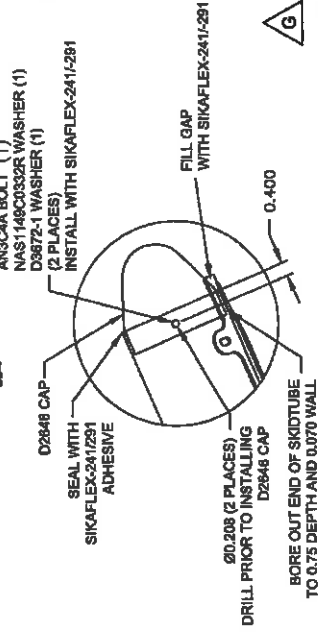


DETAIL K: END FINISHING DETAIL
B7-4



- DETAIL K NOTES
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

DETAIL L
B4-4



DESIGN	CP	RF	AK	JLM	DS	DATE	16.04.25
DRAWN							
CHECKED							
INFO. APPR.							
DE APPR.							
DATE							

RELEASED
R 2016-07-26
-045 DETAILS

DART AEROSPACE USA, INC
EUGENE, OR

DRAWING NO. D3274

REV. G

SHEET 6 OF 6

TITLE SKIDTUBE ASSEMBLY

SCALE NTS

DATE 16.04.25

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